

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027669**Date Inspected:** 08-May-2012**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Lubrite Industries**OSM Arrival Time:** 700**OSM Departure Time:** 1530**Location:** Meadville PA**CWI Name:** Brad McWright**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Spherical Bearing Hinge K**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) arrived at Lubrite Industries (LI), Meadville PA, as requested to monitor the continuation of welding of the Anchor Studs to the Anchor Plates for Bearing Assemblies HK1 and HK2.

Upon arrival this QAI met with Third Party QC Reno Davis KTA (TPQC), and Brad McWright (LIQC). First Anchor Plate was set up and locations marked for attachment of anchor studs to plate. The plate material is ASTM A709 Grade 50 Heat 0502434. Anchor studs are 1" x 8 1/4" ASTM A108/A29 Grade 1015 Heat 5093721. The original qualified stud gun was set up for use due to the previous day malfunction of the new equipment.

Qualified LI Welder then proceeded to weld (3) test studs to a sample plate and perform bend test on all three before proceeding to production pieces. The first production piece was set up and (8) Anchor studs were welded to the Plate with no failures. Welds were inspected by TPQC and witnessed by this QAI. Visual inspection revealed no surface defects. The TPQC requested a bend test be performed on one stud for verification of full fusion. Stud was bent 15 degrees with no sign of tearing from base metal. The welder then proceeded to weld the anchor studs to the remainder of the anchor plates. Plate HK2-A7 was returned from repairs performed at American Bridge, Coraopolis PA and (2) new studs were welded to plate.

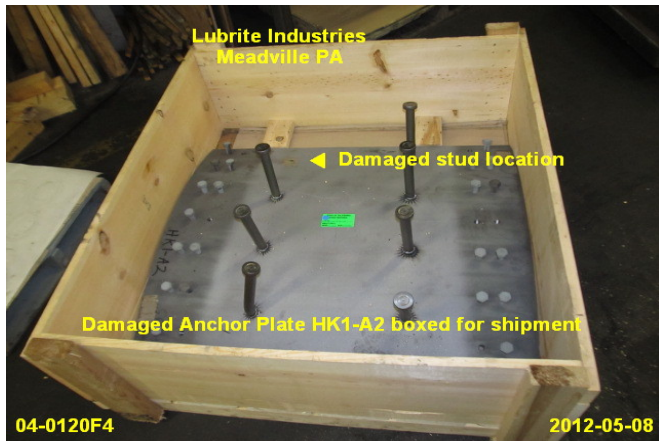
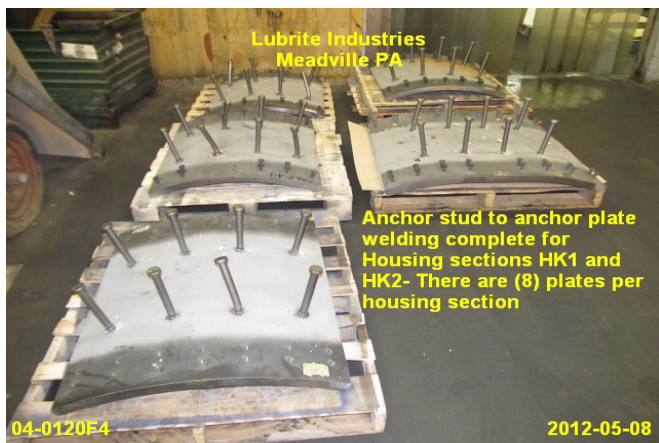
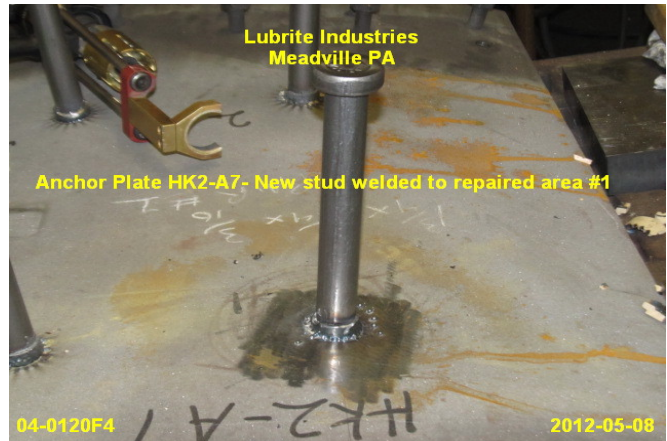
Anchor plates welded on this date were HK1-A1, HK1-A3, HK1-A4, HK1-A5, HK1-A6, HK1-A7 and HK2-A7.

The damaged Anchor plate HK1-A2 was boxed, Green tagged with blue dot and shipped to American Bridge in Coraopolis, PA for repairs. The assigned Lot Number is S26-012-12.

The items observed appear in general conformance with the contract documents and approved drawings.

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Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and LI QC Personnel.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Aaron Prchlik (510)-610-9822, who represents the Office of Structural Materials for your project.

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| Inspected By: | Sullivan, Kevin | Quality Assurance Inspector |
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| Reviewed By: | Foerder, Mike | QA Reviewer |
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